

Work Order ID 133788 - 2

133788

Page 1

Wednesday, June 17, 2015 2:52:44 PM

Item ID: D3886-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug Assembly

Start Date: 6/17/2015 Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/17/2015 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: JUN 17 2015 Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3886	B
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100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

FLOW WATER JET

1-Cut as per Dwg D3886-3

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

20 0 JM15-6-17

20 0 JM15-6-17

SPLIT

304.100

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Page 2

Accept

Setup Start *NS1*

Stop *NS2*

20

Cust Item ID:

Start Date: 6/17/2015 Start Qty: 20.00

Required Date: 6/17/2015 Req'd Qty: 20.00

20

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00

120

0.00

QC

Memo

Quality Control

0.00

130

130

0.00

Brake NC

Memo

Brake NC

form as per dwg D3886

DAS
30
9-89

JUN 22 2015

140

QC5- Inspect part completeness to step on W/O

0.00

140

0.00

QC

Memo

Quality Control

20

JUN 23 2015

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Quality Control

8 15-07-16 JBR

(8) 15.07.16

(8) 15.07.16

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133788

Page 4

Item ID: D3886-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lug Assembly
 Start Date: 6/17/2015 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 6/17/2015 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M131545</i> Memo	0.00 <i>START: 11:15</i> <i>OPEN: T: 4:00</i> <i>FINISH: 4:45</i>				<i>8</i>	<i>15.7.20</i>	<i>DAS 34 9-89</i>	
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00				<i>(8)</i>		<i>DAS 38 9-89</i>	JUL 21 2015
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <i>st 529</i> Memo	0.00				<i>8</i>		<i>DAS 27 9-89</i>	JUL 21 2015

Work Order ID 133788

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133788

Page 5

Item ID: D3886-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug Assembly

Start Date: 6/17/2015 Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/17/2015 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

ML5

JUL 2 2 2015

ML5

JUL 2 1 2015

Picklist Print

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Page 1

Work Order ID: 133788

133788

Parent Item: D3886-041

D3886-041

Parent Item Name: Lug Assembly

Start Date: 6/17/2015

Required Date: 6/17/2015

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S12GA

Purchased

No

100

sf

74.2313

0.1472

3

M304S12GA

**

Jm 15-6-17

304/316 0.100" Sheet

Location

Loc Qty

Loc Code

MAT019

74.2313

m131322

74.2313

131322

D3886-1

Manufactured

No

150

Each

18.0000

1

20

D3886-1

**

15-07-16

Lug

Location

Loc Qty

Loc Code

WA002

18

131067

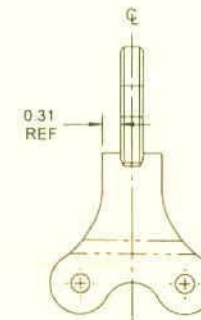
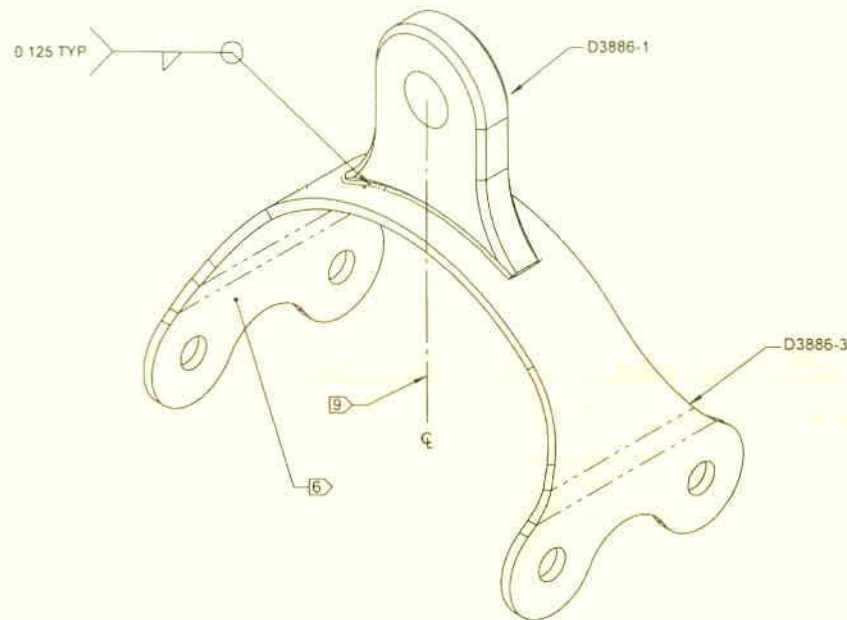
8

133168

10

8

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3886-041	LUG ASSEMBLY
2	1	D3886-1	LUG
3	1	D3886-3	BRACKET



133788 MJS
150617

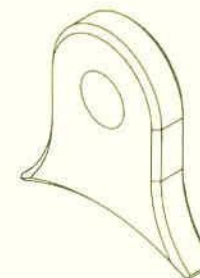
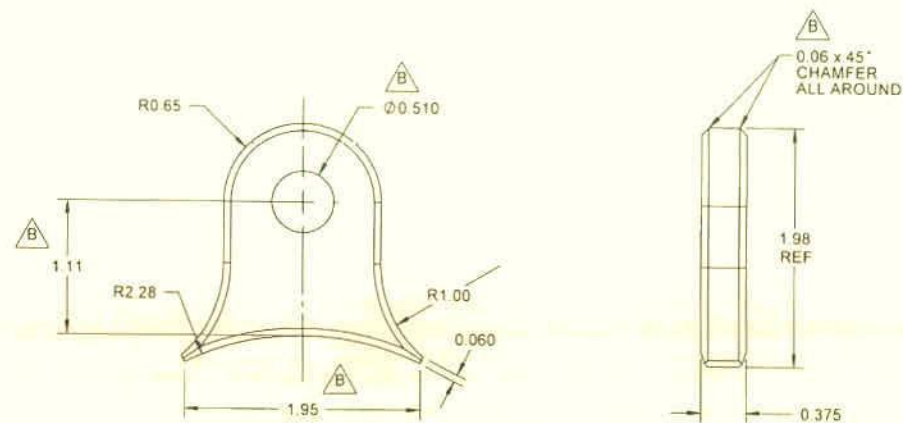
D3886-041 LUG ASSEMBLY

RELEASED
8/6/72 MBD

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "WHITE" (4 3 5 1) PER DART QSI 005 4 3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3886-041" AND BATCH NUMBER USING FINE POINT PERMANENT INK MARKER ON UNDERSIDE OF PART
- 7) WEIGHT: 0.53 lbs
- 8) WELD PER DART QSI 004
- 9) BOTH PARTS CENTER SHOULD BE IN LINE WITH THE ϕ

B	RE DESIGN D3886-1 (ZN B4-2), RE-DESIGN D3886-3 (ZN A4-3), REVISED D3886-3F (ZN B4-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG APPR.	RF	D3886	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	LUG ASSEMBLY	NTS
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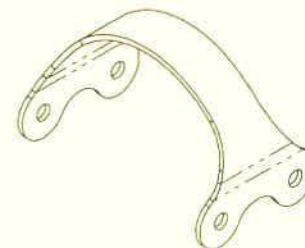
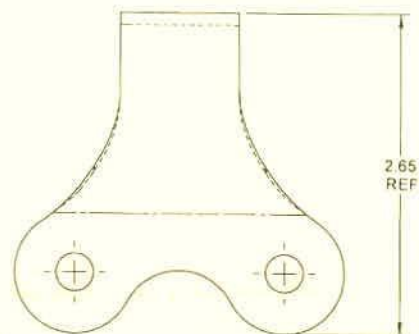
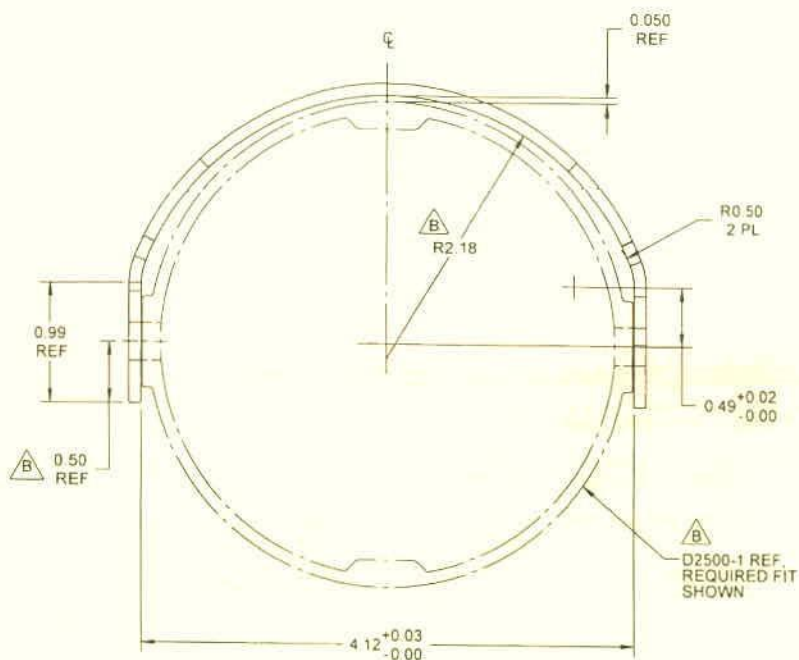
D3886-1 LUG $\triangle B$

NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR (REF. DART SPEC. M304B0.750X2.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

RELEASED
09/07/13

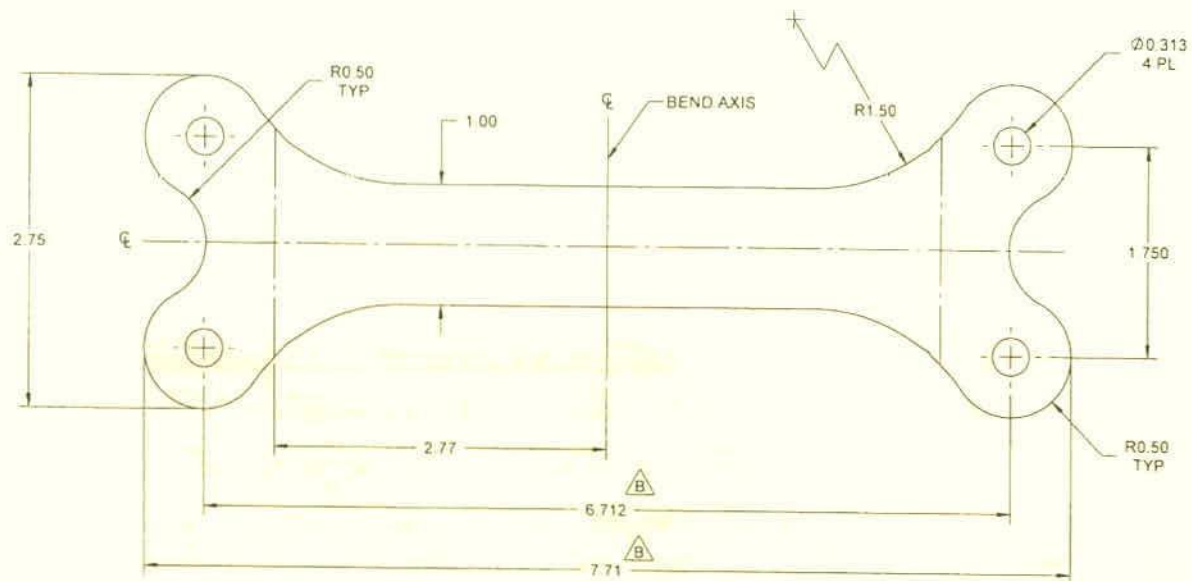
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CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG APPR.	<i>RF</i>	D3886	SHEET 2 OF 4
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DE APPR.	<i>RF</i>	LUG ASSEMBLY	NTS
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D3886-3 BRACKET B
(MAKE FROM D3886-3F)

RELEASED
09/07/15/16

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MFG. APPR.	<i>RF</i>	D3886	SHEET 3 OF 4
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DE APPR	<i>RF</i>	LUG ASSEMBLY	NTS
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D3886-3F FLAT PATTERN $\triangle B$

RELEASED
8/27/54

NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 12 GAUGE (0.100) THICK, (REF DART SPEC. M304S12GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.30 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV B
MFG APPR.	<i>[Signature]</i>	D3886	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
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